

Date: Thursday, 3/9/2006 8:30:09 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BLOWER MOTOR SUPPORT
<b>Job Number</b> : 26171	
<b>Estimate Number</b> : 12311	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3471041
<b>This Issue</b> : 3/9/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3471 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 3/30/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : SEE ABOVE USER & DATE	
<b>Comment</b> : est rev A 06.03.02 New issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3471043	SUPPORT AND CLAMP ASSEMBLY
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: qty part number description batch 2 D3471-043 CLAMP ASS'Y <del>① H100393</del> B 26268		
2.0	MS20470AD45	Rivet, Universal Head
<b>Comment:</b> Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: qty part number description batch 8 MS20470AD4-5 Rivet M18461		
3.0	D34711	BASE
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) BASE D3471-1 B 26125		
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D3471		
5.0	QC5	INSPECT WORK TO CURRENT STEP
<b>Comment:</b> INSPECT WORK TO CURRENT STEP		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 1 Date: 06/03/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 8:30:10 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26171

Part Number: D3471041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 04/03/29

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

SB 06/03/30

Job Completion



W 06-03-30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

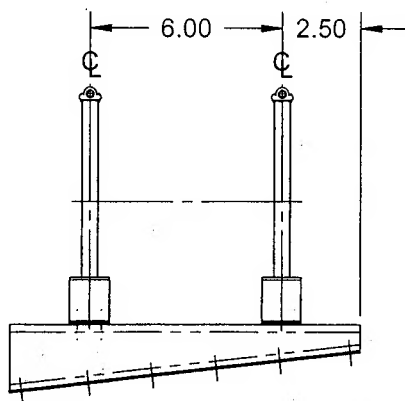
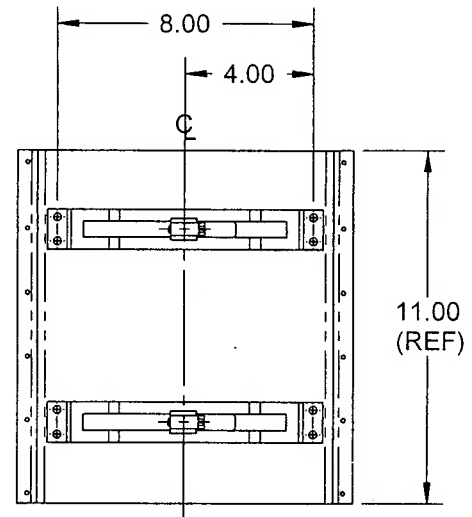
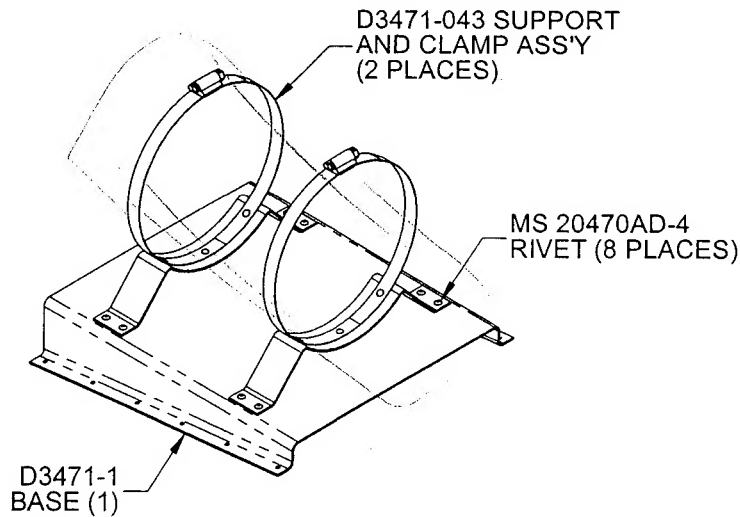
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

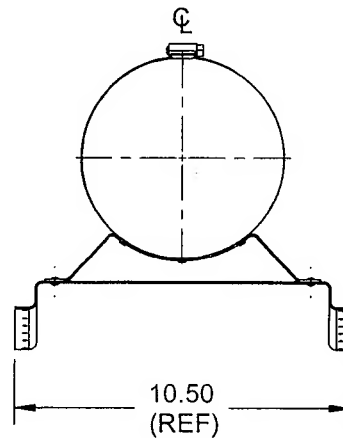
**NOTE:** Date & initial all entries

PRELIMINARY ISSUE

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 1 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:6
A	05.12.21	NEW ISSUE	



Parts List



### D3471-041 BLOWER MOTOR SUPPORT

#### NOTES:

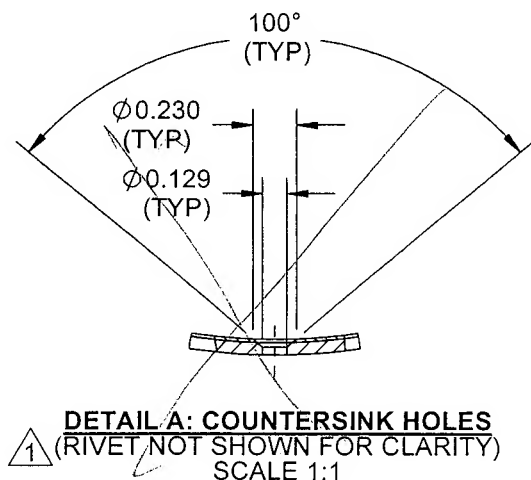
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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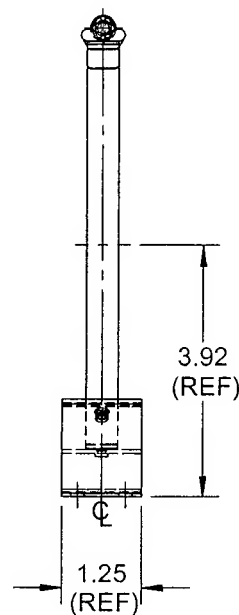
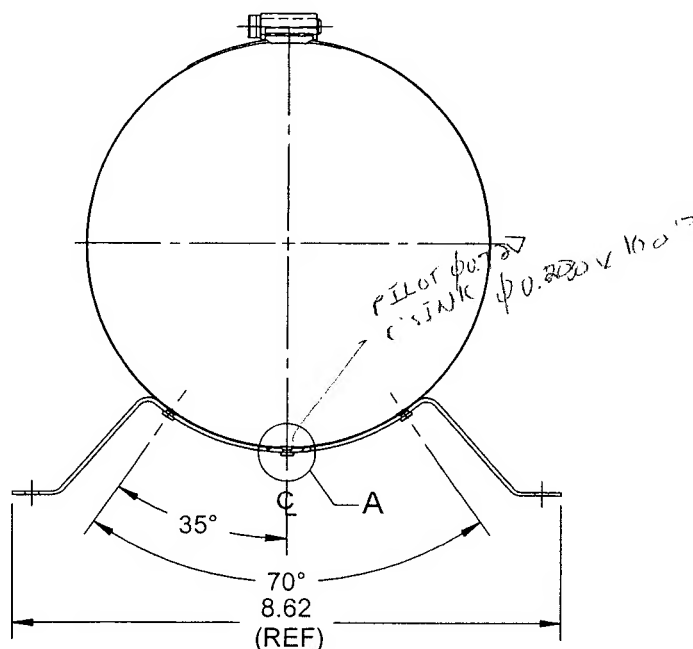
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:3



MS35842-16 CLAMP  
(2 PLACES)

MS20427M4 RIVET  
(3 PLACES)

D3471-3



### D3471-043 SUPPORT AND CLAMP ASS'Y

#### NOTES:

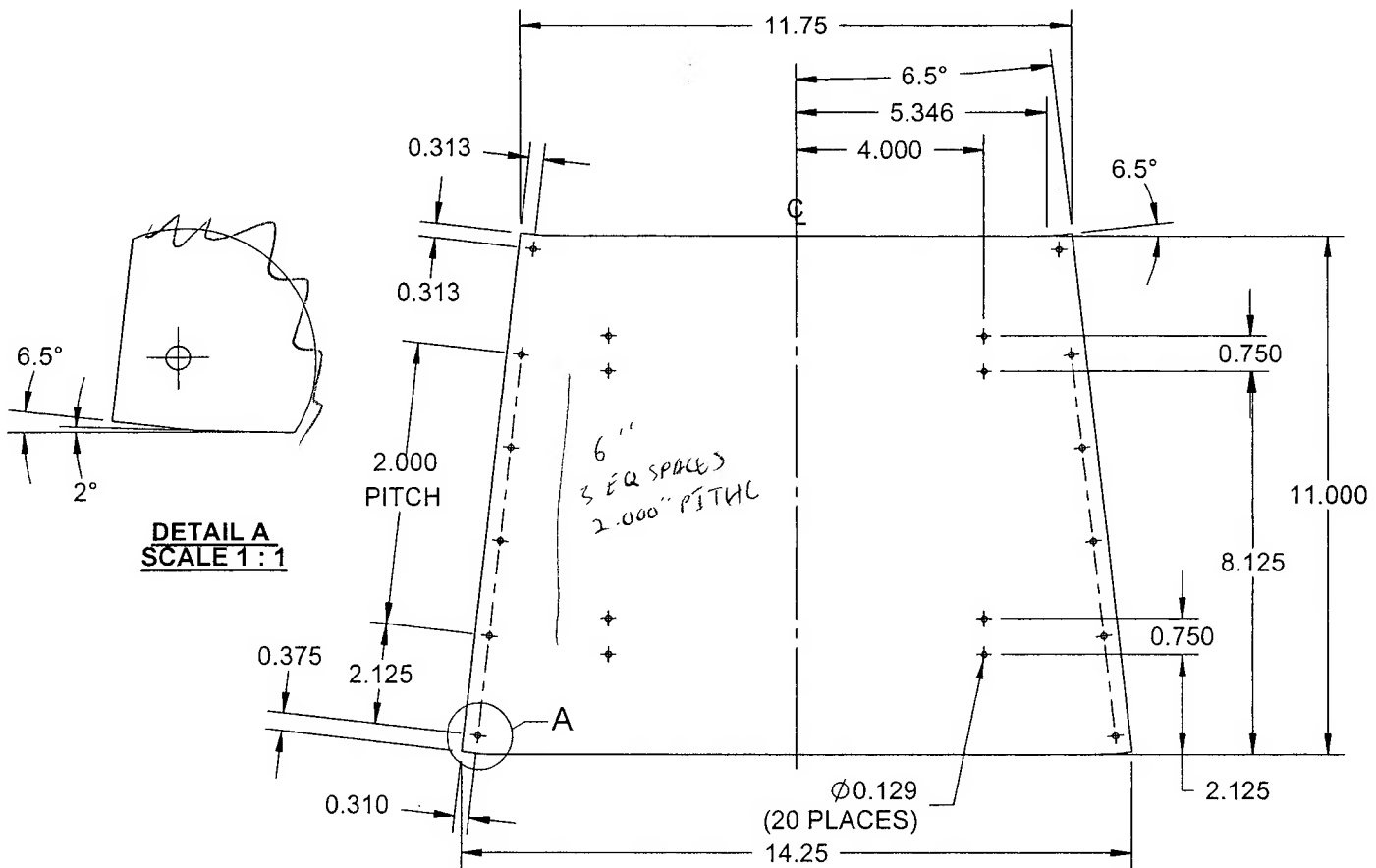
- 1) LOCATE MS35842-16 CLAMP AND TRANSFER DRILL #30 (0.129") HOLES FROM D3471-3 TO MS35842-16 CLAMP. COUNTERSINK AS SHOWN ON DETAIL A (3 PLACES).
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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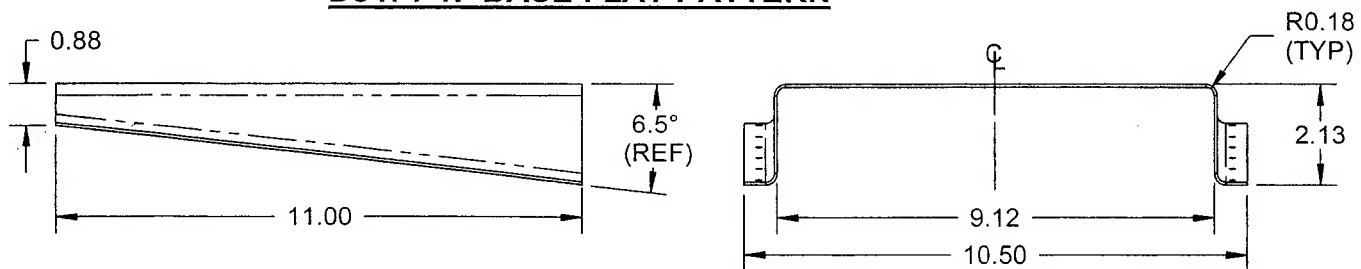
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT SCALE 1:4	



**D3471-1F BASE FLAT PATTERN**



**D3471-1 BASE BENDING DETAIL**

**NOTES:**

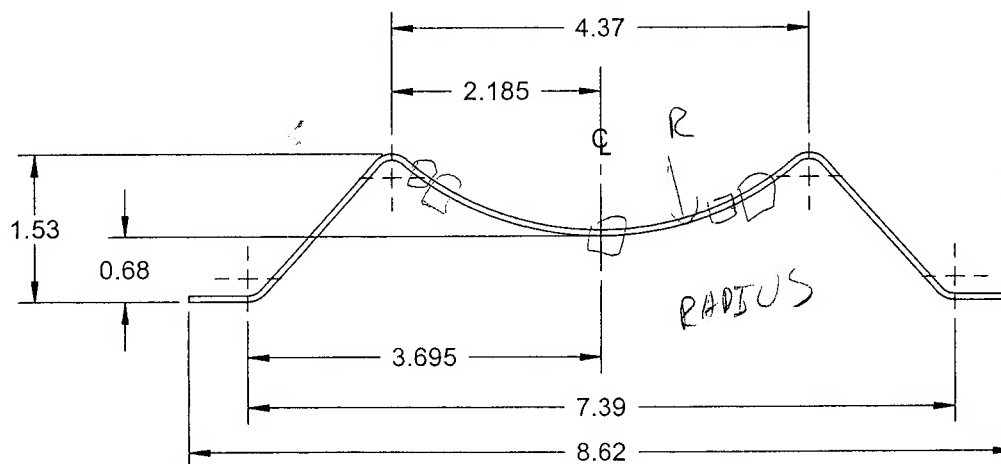
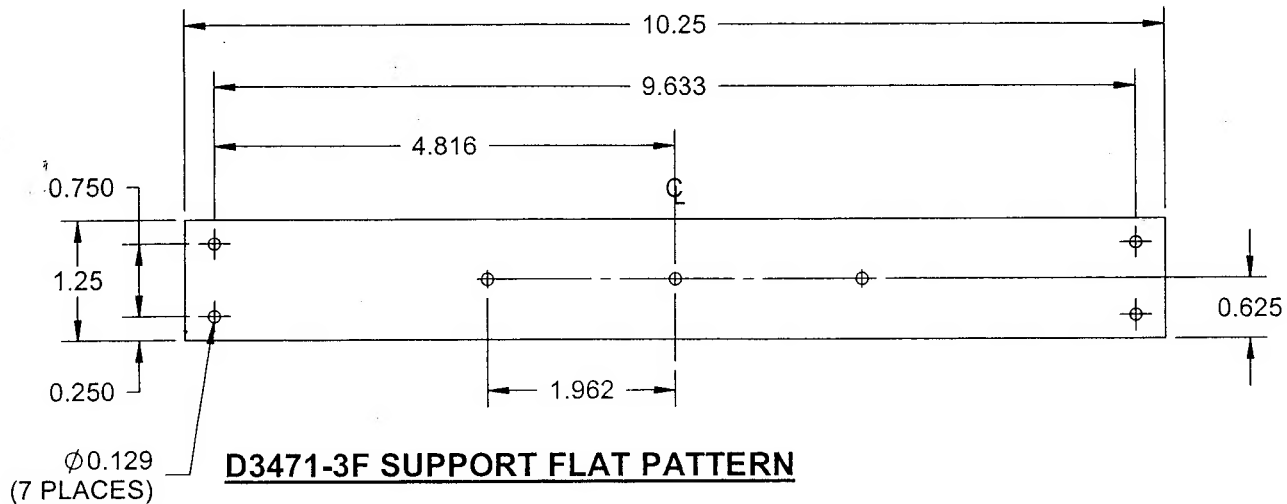
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:2



### **D3471-3 SUPPORT BENDING DETAIL**

#### **NOTES:**



- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

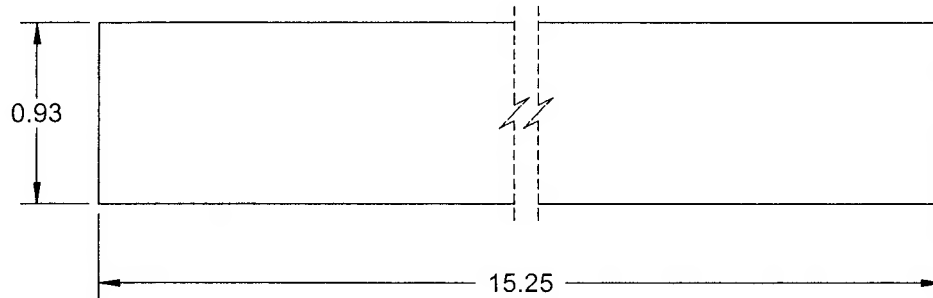
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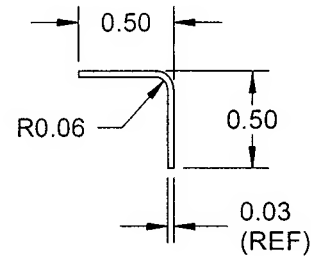


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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:1



**D3471-5F STIFFENER FLAT PATTERN**



**D3471-5 STIFFENER  
BENDING DETAIL**

**D3471-5 STIFFENER**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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